

Date: Thursday, 3/13/2008 10:19:03 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 37921	
Estimate Number : 10530	
P.O. Number :	Part Number : D2571
This Issue : 3/13/2008 S.O. No. :	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 37564	Material :
Written By :	Due Date : 4/4/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JA 080313</u>	
Comment : Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351.8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: B31389

ml 08/03/29

10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 37921 Double check by: DIP

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

ml/JL 08/04/02

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

ml/JL 08/04/02

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

/JL 08/04/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:03 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37921

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SE 08/04/02

(10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/04/02

(10X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 107550

BR

08-04-05

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

F2

08/04/03

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

st 432

08/4/2

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



u 08.04.04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37921
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

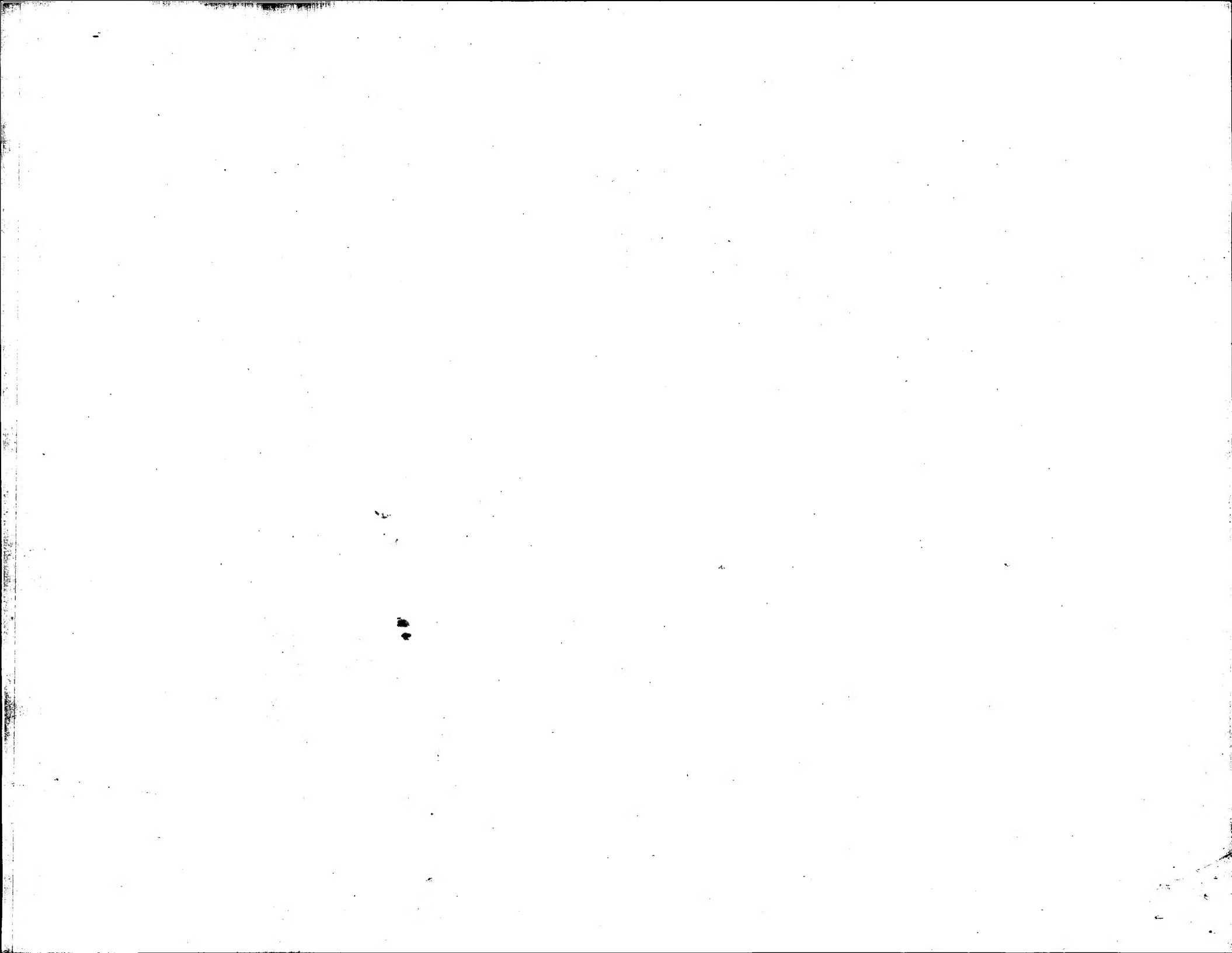
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.002	8.002	8.001		
F	0.490	0.510		.500	.502	.503	.499		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.497	.499	.500	.500		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.565	.566	.566	.565		
L	1.174	1.184		1.178	1.178	1.178	1.179		
M	1.490	1.500		1.495	1.496	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	3.869	3.879		3.873	3.874	3.874	3.874		
P	0.115	0.135		.124	.124	.125	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	.249		
S	0.115	0.135		.134	.132	.133	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.957	2.958	2.958	2.958		
V	0.230	0.250		.246	.239	.239	.240		
W	0.115	0.135		.121	.128	.124	.125		
X	0.308	0.313		.309	.309	.309	.308		
Y	0.760	0.765		.766	.766	.766	.760		
Z	0.352	0.372		.362	.361	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.633	.634	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.247	.247	.247		
AE	1.375	1.395		1.387	1.386	1.387	1.387		
AF	0.115	0.135		.132	.135	.134	.135		
AG	0.240	0.280		.257	.255	.255	.255		
AH	0.240	0.260		.249	.249	.248	.248		
AI	2.000	2.020		2.002	2.001	2.002	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	MR / JL
Date:	08/04/01

Audited by:	RF
Date:	08/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order:	37921
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	A ₅	A ₆	A ₇	A ₈	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.001		
F	0.490	0.510		.498	.499	.500	.501		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.501	.501	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.565	.568	.568	.570		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.123	.123	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.250	.249		
S	0.115	0.135		.134	.130	.129	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.958	2.958	2.958		
V	0.230	0.250		.240	.239	.239	.240		
W	0.115	0.135		.128	.123	.123	.120		
X	0.308	0.313		.309	.308	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.363	.365	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.620	.621	.622	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.249	.247	.246		
AE	1.375	1.395		1.387	1.386	1.389	1.388		
AF	0.115	0.135		.132	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.248	.248	.248		
AI	2.000	2.020		2.000	2.000	2.002	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>gml / JL</i>
Date:	<i>08/04/01</i>

Audited by:	<i>S.F.</i>
Date:	<i>08/04/02</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 3792
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

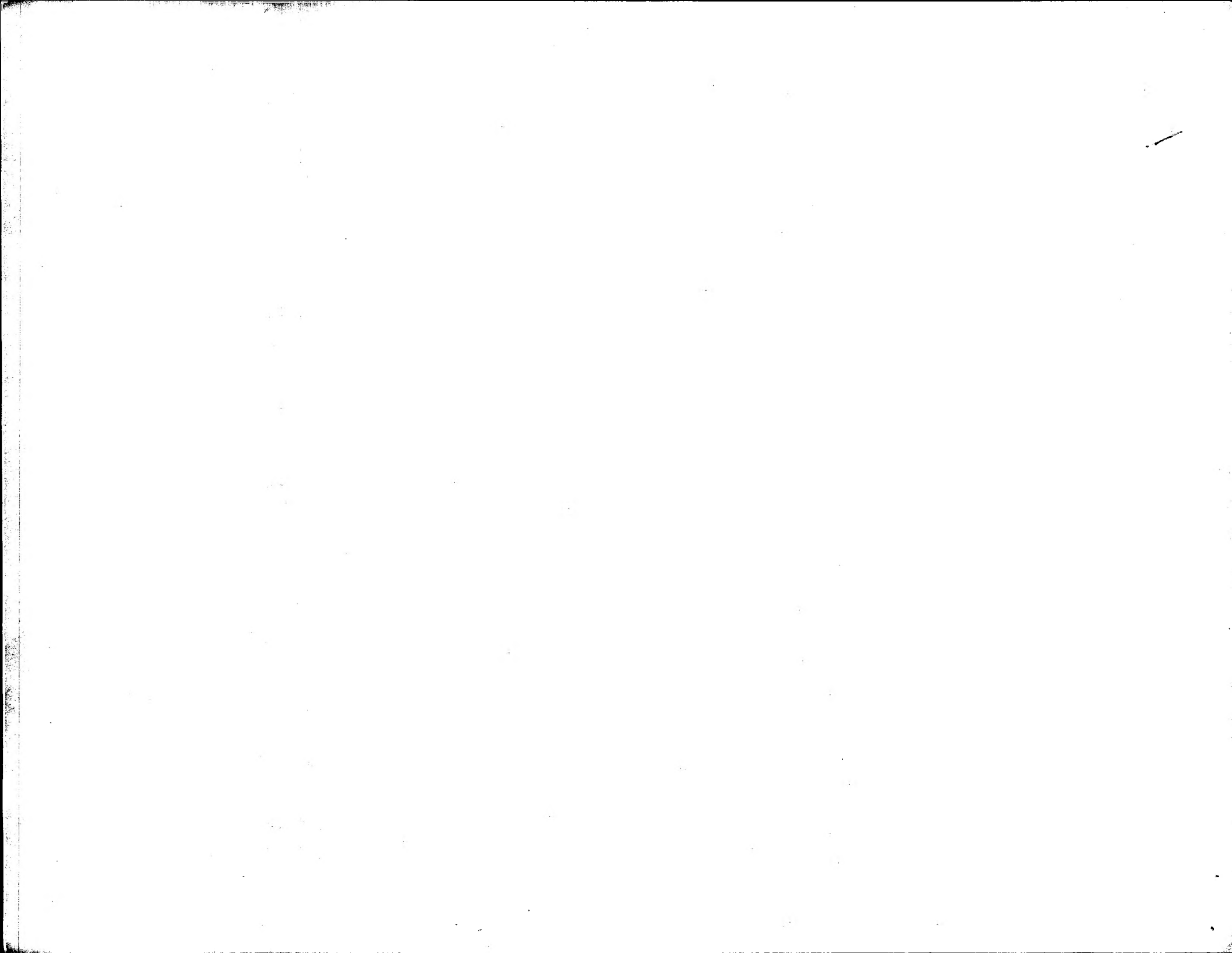
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 ₉	2 ₁₀	3	4		
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.000				
F	0.490	0.510		.500	.502				
G	0.257	0.262		.260	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.502	.502				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.123	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.249	.250				
S	0.115	0.135		.127	.126				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.958	2.958				
V	0.230	0.250		.241	.241				
W	0.115	0.135		.124	.126				
X	0.308	0.313		.308	.309				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.362	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.620	.621				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.245	.248				
AE	1.375	1.395		1.389	1.387				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.248	.249				
AI	2.000	2.020		2.002	2.000				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	J.L.
Date:	08/04/02







Audited by:	S.F.
Date:	08/04/02

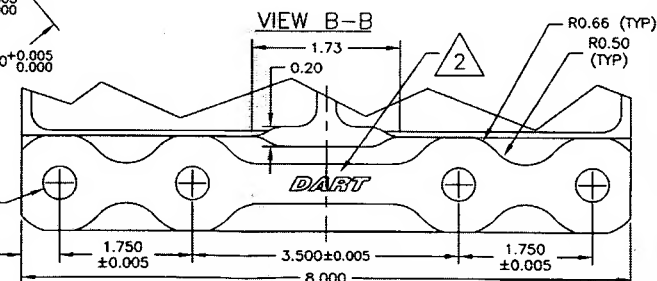
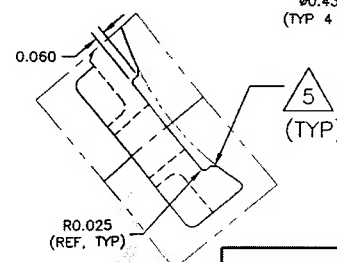
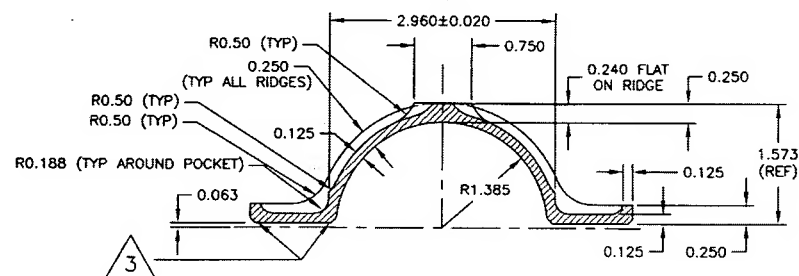
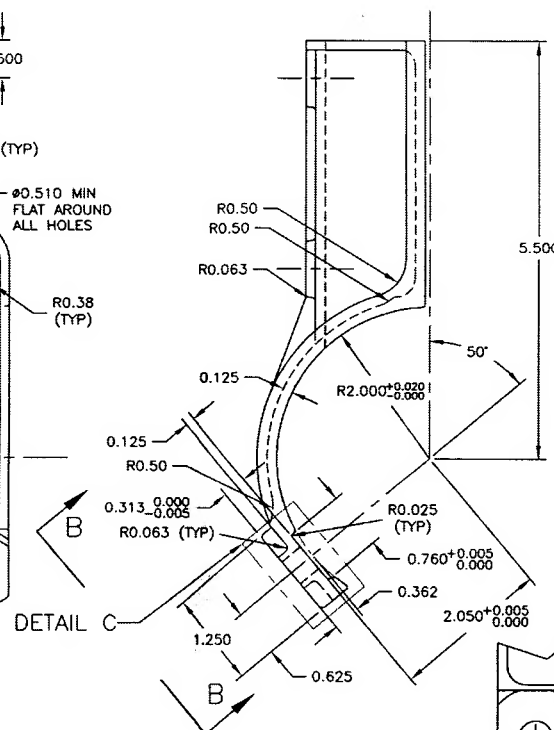
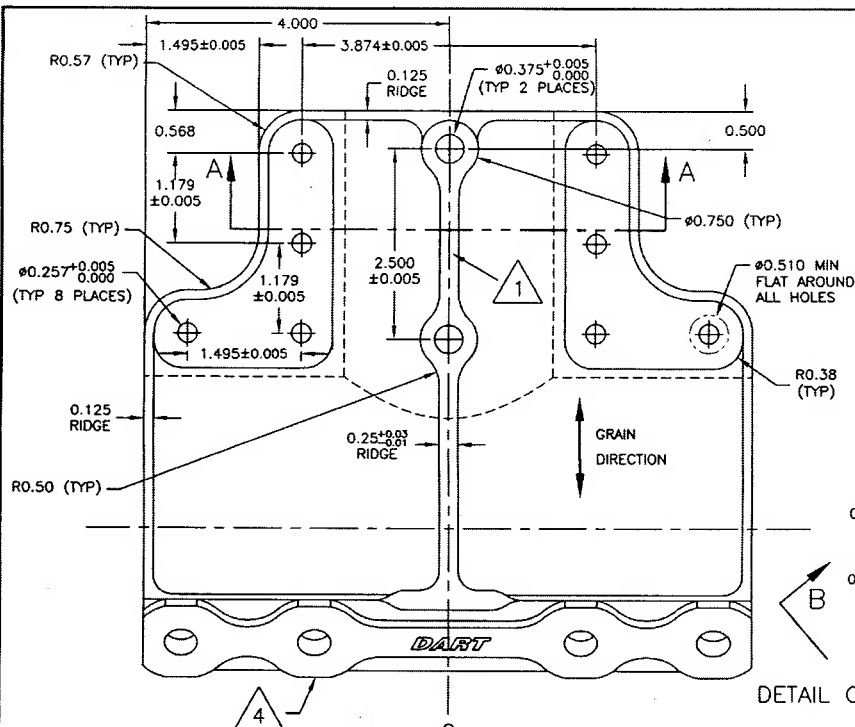
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

 $\triangle E$ 

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	NEW ISSUE	
DS	PH	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2571	REV. E SHEET 1 OF 1
DATE 05.07.13	TITLE OUTER FWD SADDLE		SCALE 2:3

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DART AEROSPACE LTD.

DART DART AEROSPACE LTD.
HAMMERSBURY, ONTARIO, CANADA

DRAWING NO.	REV. E
D2571	SHEET 1 OF 1
TITLE	SCALE
OUTER FWD SADDLE	2:3

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NO. 37921